

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016021**Date Inspected:** 03-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng wei / Li yan hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

SMAW welding of weld joint 2F-059 located on PCMK SEG3005 for Segment 12AW the welder is identified as 067183. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2112.

SMAW welding of weld joint 3F-036 located on PCMK SEG3005 for Segment 12AW the welder is identified as 067183. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2113.

SAW welding of weld joint 1G-003 located on PCMK SEG3015A for Segment 13CW the welder is identified as 045270. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2c-S-2.

FCAW welding of weld joint 1G-013 located on PCMK SEG3015 for Segment 13CW the welder is identified as 201215. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

SMAW welding of weld joint 2F-030 located on PCMK SEG3005B for Segment 12BW the welder is identified as

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067183. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2112.

SMAW welding of weld joint 3F-076 located on PCMK SEG3005H for Segment 12BW the welder is identified as 045268. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2113.

BAY#19

FCAW welding of weld joint 2G-049 located on PCMK SB020-084 for OBG SB84E the welder is identified as 062783. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

Visual inspection of Weld joint fit-up dimension, tack weld checked of the following suspender bracket is identified as SB72W and SB80E.

BAY#16

FCAW welding of weld joint 2F-010 located on PCMK LD3033-001 for Segment 13CW the welder is identified as 201583. ZPMC QC is identified as Mr. Xia chun hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

Segment 13AW, during cutting of hole in bottom plate of 100mm thickness is identified as BP3074-001, some of the holes have notch inside the hole having the depth 3~5mm the plate is identified as PL3361C- 3 locations; PL3362C-3 locations; PL3363C-3 locations. ZPMC is waiting to get approval for CWR prior to repair.

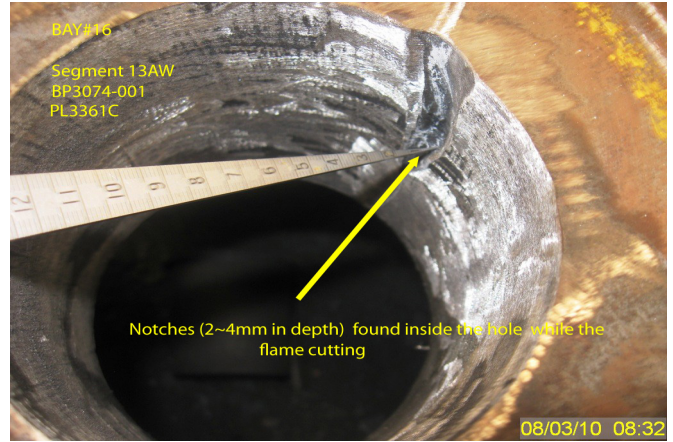
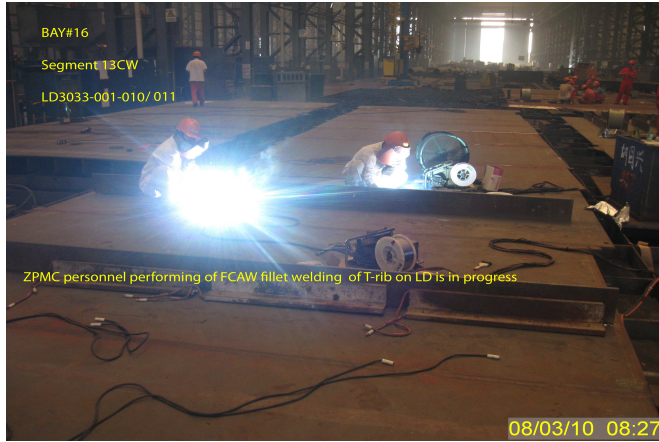
BLAST SHOP#1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 10CW Bottom panel, Side panel Exterior surfaces from the panel point 92 to 94 after grit blasting. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
